



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

Order 3234

003569
003571

C2-C
Job Sheet 176684



Part No: C2-C

Job Qty: 1 ea

Part Name: Single Cage



Part Weight: 0 lbs

Status: Scheduled *A+ Planning*

Priority: Medium

Job Created: 4/27/18

Job Tracking No:

Due Date: 5/11/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG C2-C Rev. 0 IPP Rev. A 18.04.25 new issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup	Run	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		5/11/18	0.00	0.00	Start Up Small Fab-1		18-05-31 <i>JB</i>
100	Small Fab	1 pcs		5/11/18	0.00	0.50	Small Fab-9		<i>AP</i>
120	QC	1 pcs		5/11/18	0.00	0.00	QC5		<i>SB</i>
140	Packaging	1 pcs		5/11/18	0.00	0.00	Packaging3-1		<i>SB</i>
160	QC21-SA	1 Ea		5/11/18	0.00	0.00	QC21		<i>SB</i> MAY 31 2018

Part Op 100 - ASSEMBLE AS PER DWG ***HAND TIGHTEN ALL BOLTS, SPREAD COTTER PIN JUST ENOUGH SO THAT IT
Descriptions: WILL NOT FALL OUT***

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN6-22A	Bolt	1 Ea (1 ea)	90-Start up Operation	<i>FM138403-0</i>
AN310-6	Castellated Nut	1 Ea (1 ea)	100-Small Fab	<i>F122459-40</i>
AN5-21A	Bolt	2 Ea (2 ea)	100-Small Fab	<i>S057451</i>
C2-20-21	Cotter Pin	1 (1 ea)	100-Small Fab	<i>S068055</i>
C2-20-5	Weldment	1 Ea (1 ea)	100-Small Fab	<i>S075393</i>
C2-21P	Lifting Bushing C2 Cage	1 pcs (1 ea)	100-Small Fab	<i>S029526</i>
MS21044N5	Nut	2 Ea (2 ea)	100-Small Fab	<i>S057526-1</i>
NAS1149F0563P	Washer	4 Ea (4 ea)	100-Small Fab	<i>S061998</i>
NAS1149F0663P	Washer	2 Ea (2 ea)	100-Small Fab	<i>S051477-1</i>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	AN6-22A	1	8	0
100-Small Fab	AN310-6	1	15	0
	AN5-21A	2	53	0
	C2-20-21	1	0	0
	C2-20-5	1	0	0
	C2-21P	1	25	0
	MS21044N5	2	99	0
	NAS1149F0563P	4	165	0
	NAS1149F0663P	2	983	0

Part Specifications

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Date : _____		Step #: _____		QTY Effective : _____		MRB (QSI042) Approval															
Description Work DART Aerospace Ltd. 1270 Aberdeen Street Hewkesbury, ON K6A 1K7 CANADA TEL: 1 813 632 - 5200 Email: sales@dartaero.com www.dartaerospace.com Container No: S076826 Part: C2 - C Job No: 176684 Serial No/Batch: S076826 Revision: 0 Inspector: _____ Exp Date: 05/31/2018 Instructions: _____ Root Cause <table style="width:100%;"> <tr> <td style="width:50%;"> Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ </td> <td style="width:50%;"> No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐ </td> </tr> </table> OTHER : _____								Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval											
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Specifications could not be found.

Plex 4/27/18 10:48 AM Dart.lajeunesse.marie

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
C2-21				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

****MAKE SURE YOU ARE USING THE CORRECT TEST FORM FOR THE CORRECT SOLENOID!****

OLD SOLENOID (H2817-024)

Work Order

176684

Customer

Serial Number

5076667
AC 110 40

Date

2018/05/31

# of Releases	Load (Lbs.)	Release Method	Remarks	Result	Pass/fail
1	5,000	Static Hold	Hold for two Minutes and reduce load to zero	N/A	Pass
10	1,000	Electircal, 25 volts	No "hang ups" permitted	N/A	Pass
2	2,000	Electircal, 22 volts	Current shall not exceed 5.4A	3.9 Amp.	Pass
2	1,500	Electircal, 22 volts	Current shall not exceed 5.4A	3.5 Amp.	Pass
2	1,000	Electircal, 22 volts	Current shall not exceed 5.4A	3.5 Amp.	Pass
2	500	Electircal, 22 volts	Current shall not exceed 5.4A	3.6 Amp.	Pass
2	100	Electircal, 22 volts	Current shall not exceed 5.4A	3.1 Amp.	Pass
1	2,000	Electircal, 20 volts	Current shall not exceed 5.4A	3 Amp.	Pass
1	2,000	Electircal, 28 volts	Current shall not exceed 5.4A	4.3 Amp.	Pass
1	2,000	Manual		N/A	Pass
1	2,000	Impact Test	Impact shackle 10 times, shall not release	N/A	Pass
1	N/A	Solenoid Ohms	Shall not exceed 4.9-5.4 Ohms	5.2 Ohms	Pass
1	N/A	Electircal Continuity	Across both wires	N/A	Pass

Test Conducted By:

ALAIN PATRY

Signature

Sylvie Boncher
QC 5 Small FAB / QA